Vipros 357 Queen with 18PC Programming Limits

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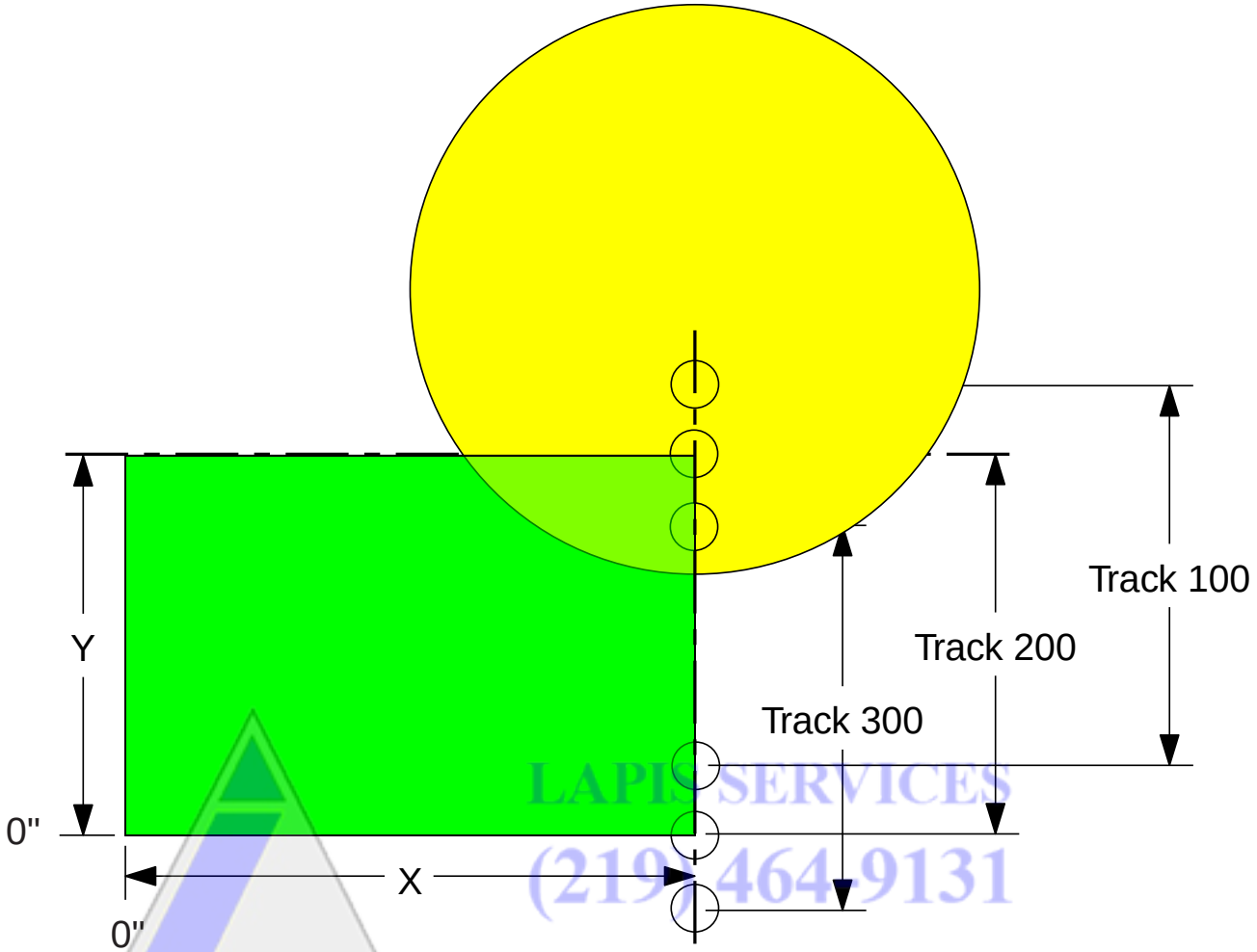
Programmable Travel Limits



Origin Statement		X-axis Movable Distance	Y-axis Programmable Distance By Track Numbers		
X-axis Origin	Y-axis Origin		Inner Track 100 Stations	Center Track 200 Stations	Outer Track 300 Stations
72.000"	50.000"	-.394" to 72.441"	1.181" to 51.579"	-.394" to 50.000"	-1.969" to 48.425"

Axis Speeds

Table Speed Punching Mode

F1 = X 2,559. IPM Y 1,968. IPM

F2 = X 1,919. IPM Y 1,476. IPM

F3 = X 1,279. IPM Y 984. IPM

F4 = X 639. IPM Y 492. IPM

Table Speed Interpolation Mode

G00 max. = X 2,559. IPM Y 1,968. IPM

G01 max. = 300. IPM

G02 max. = 300. IPM

G03 max. = 300. IPM

Turret Rotation Speed

30 RPM

Auto Index Rotation Speed

60 RPM

Punching Speed

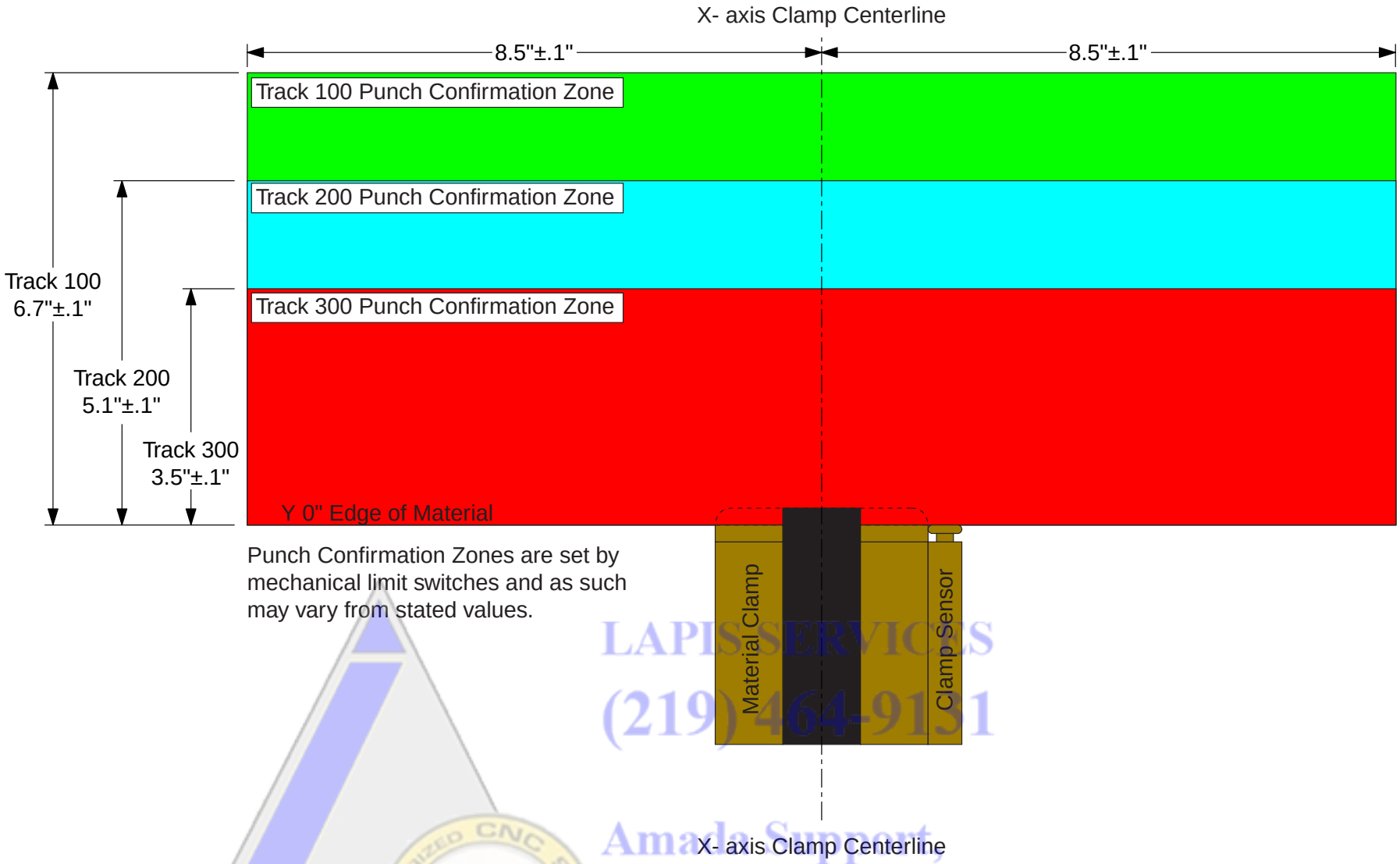
	Pitch	Stroke	Stroke Rate
Stroke Rate (X/Y)	0.079"	0.118"	520/420
	0.079”	0.236”	360/360
	0.315”	0.315”	275/275
	1.000"	0.315"	275/240

Punch Confirmation Area / Punching Dead Zone.

Definitions

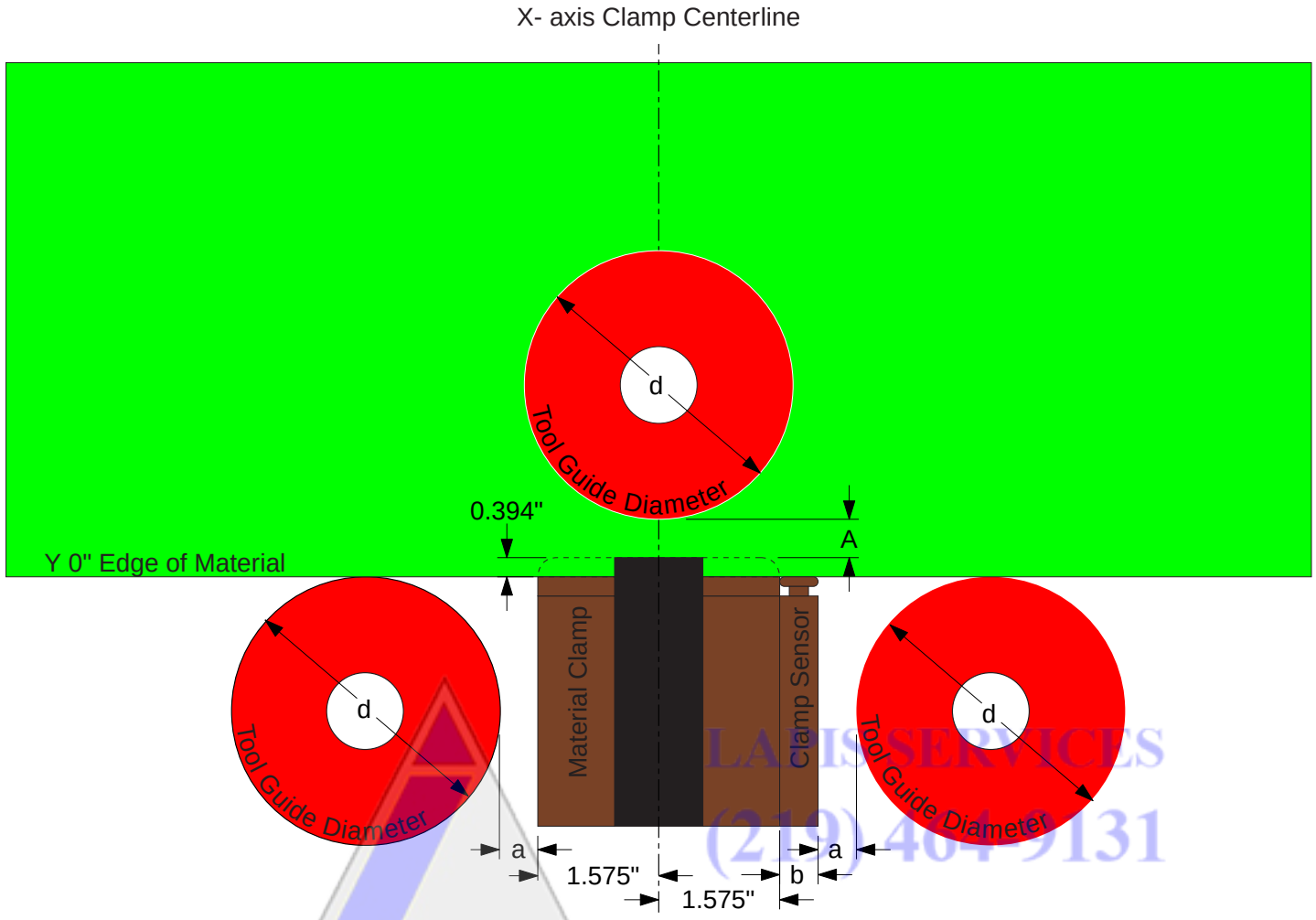
Confirmation Zone	=	An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton.
Punch Dead Zone	=	An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton. Punching in this area with standard tools may damage the material, material clamp, tool, other machine components and may cause operator injury.
Y-Overtravel Zone	=	An area that exceeds the travel limits of the machine.

Punch Confirmation Area



Punch Confirmation Zones are set by mechanical limit switches and as such may vary from stated values.

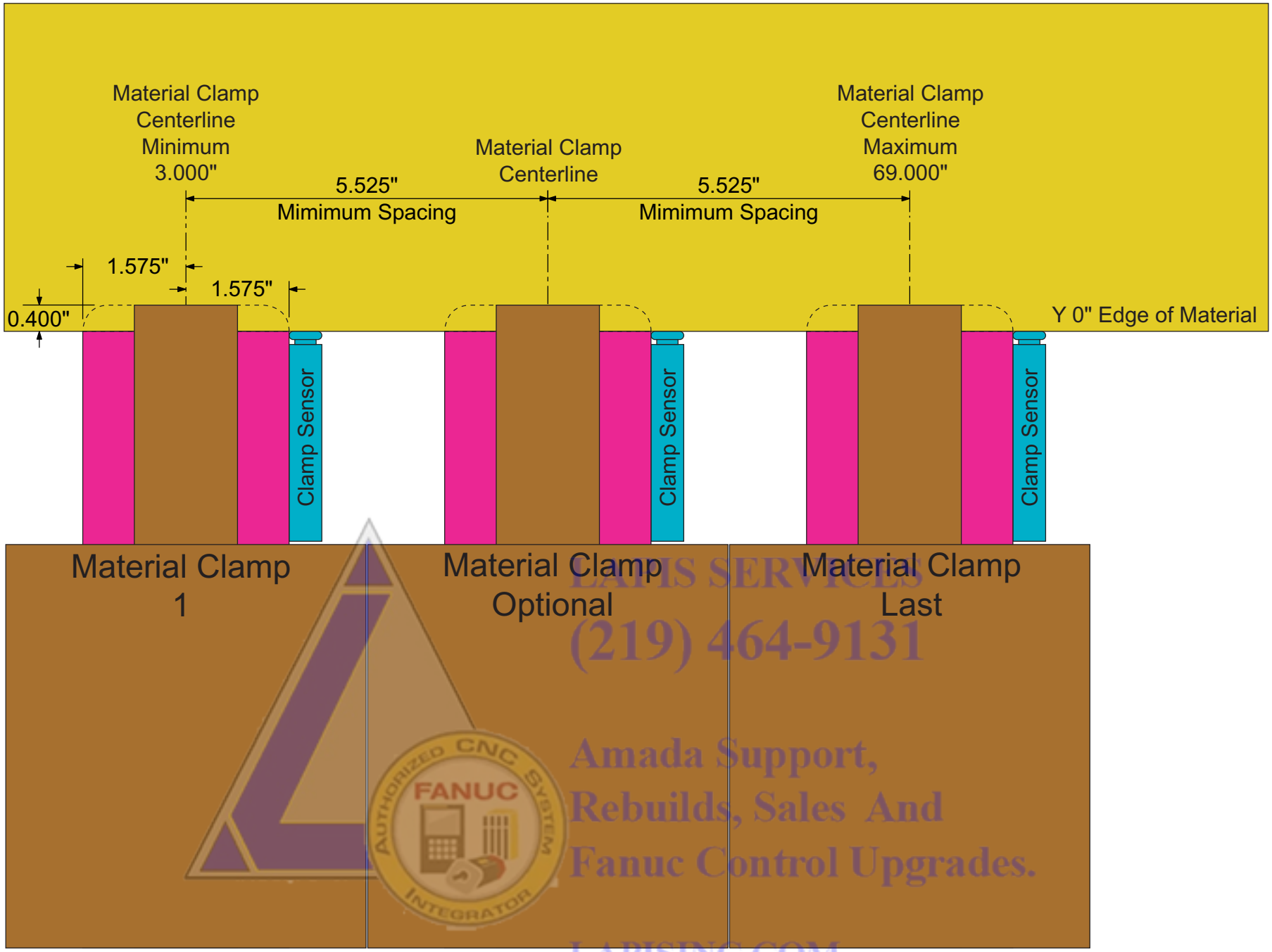
Punching Dead Zone.



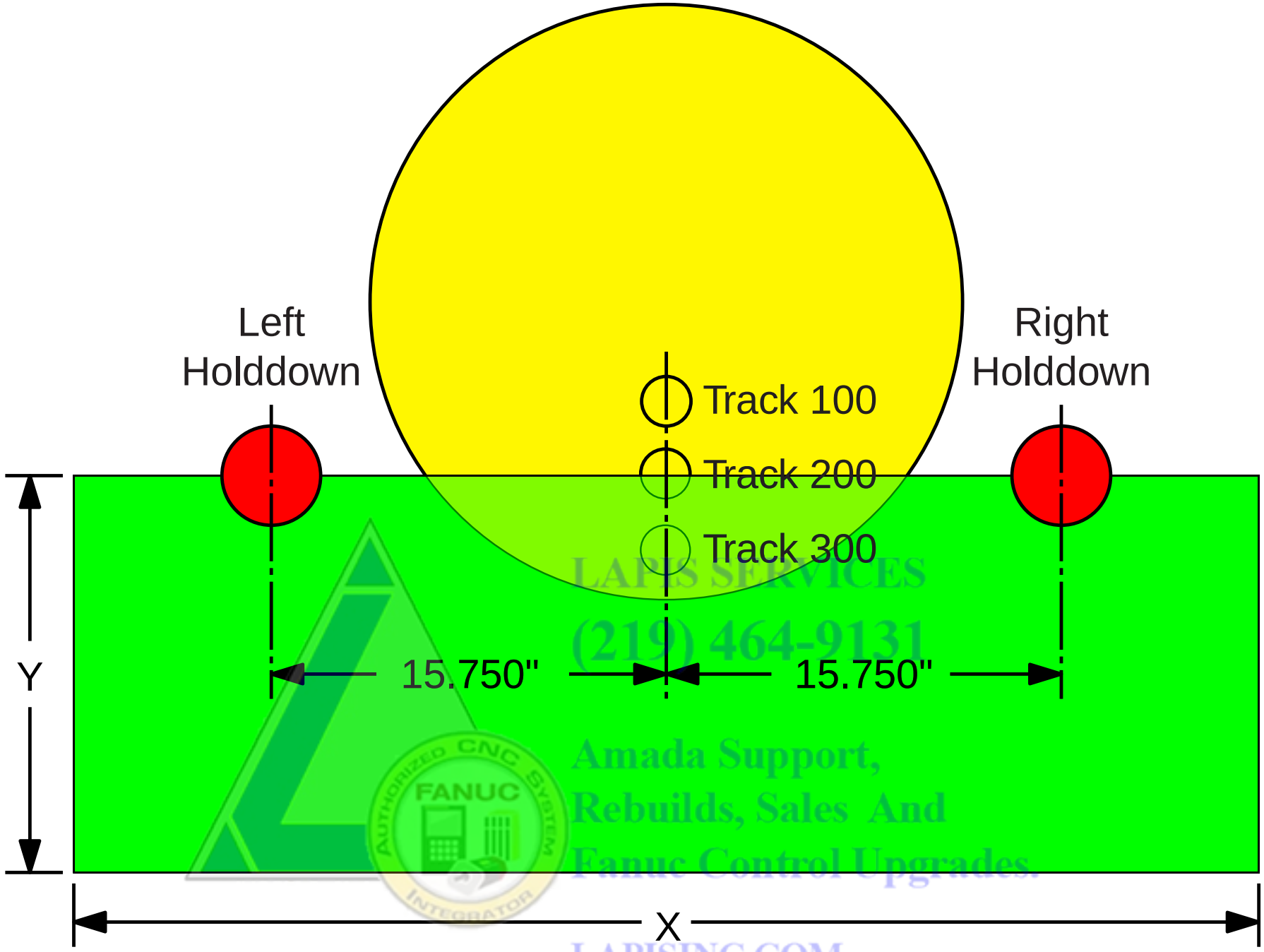
Punching Dead Zones "The punch will contact the material clamp when programmed to punch in the area described by the following calculations".		
X-axis	To the left of the clamp	Clamp position -1.575" - a - d/2
	To the Right of the clamp	Clamp position +1.575" + a + b + d/2
Y-axis	.394" + a + d/2	

b=		.500"	
a=		.500"	
d=	Station Size	A	1.020"
		B	1.883"
		C	3.500"
		D	4.938"
		E	6.250"

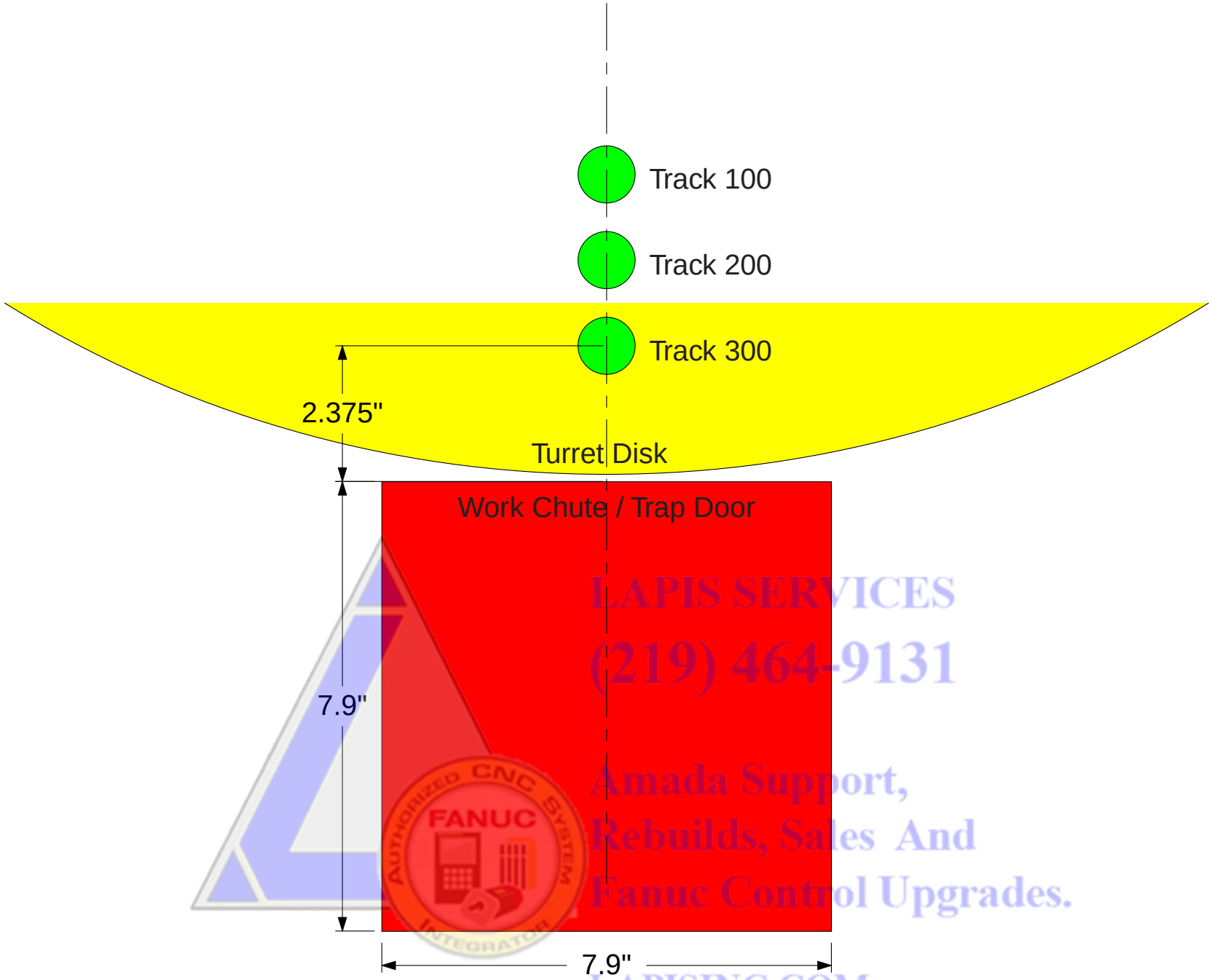
Material Clamp Locations



Reposition Holddown Locations

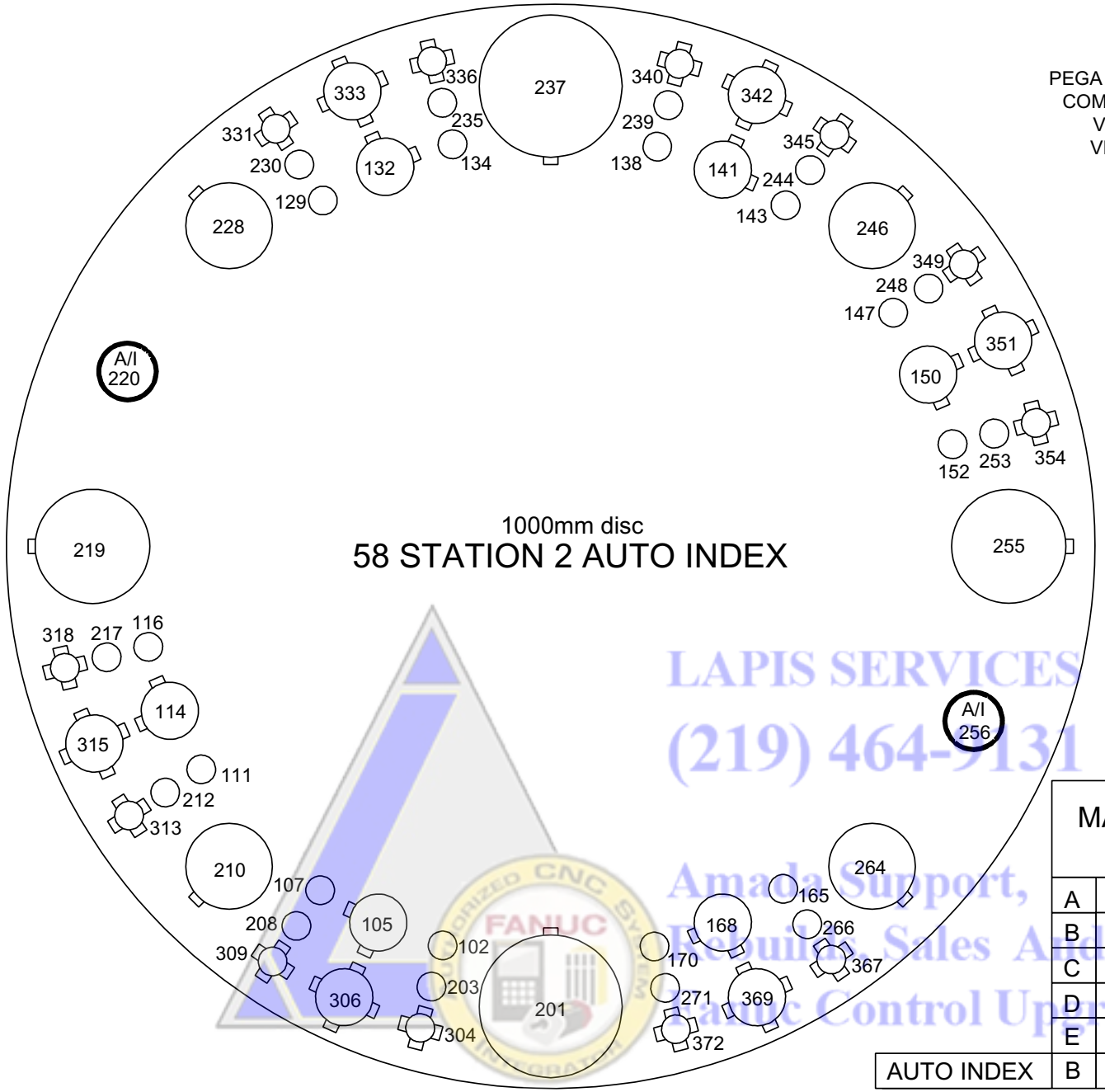


Work Chute / Trap Door (ball transfer table only)



58 Station Turret

PEGA 345, PEGA 345 King, PEGA 357, PEGA 367
COMA 555, COMA 557, COMA 567, COMA 588
VIPROS 345, VIPROS 357, VIPROS 367
VIPROS 357 Queen, VIPROS 367 Queen



MAXIMUM SIZE ROUND		NUMBER OF STATIONS (KEYED)
A	1/2" (12.7mm)	36 (12)
B	1 1/4" (31.7mm)	12 (12)
C	2" (50.8mm)	4 (4)
D	3 1/2" (88.9mm)	2 (2)
E	4 1/2" (114.3mm)	2 (2)
AUTO INDEX	B 1 1/4" (31.7mm)	2 (2)